

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000385**Date Inspected:** 30-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Danny C. White (B89) is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/Flour (ABF) for the purpose of witnessing Procedure Qualification Record (PQR) tests. On this date, the QA Inspector observed the following personnel present: Welding Inspector (CWI) Mr. Michael Johnson, ABF Representatives Mr. Tommy Gibson, Mr. Rick Clayborn and welder Mr. Dan Gordon.

The QA Inspector observed the PQR test plate known as ABF-PQR-025-2B was started and completed this day. This is the third attempt to weld this PQR test plate. Welder Dan Gordon completed (9) total weld passes in the 1G position. Mr. Johnson monitored welding amperage, voltage and travel speed parameters. The welders are using .072 inch diameter (1.8mm) Hobart Fabshield XLR8 E71T-8 (FCAW-S) process and utilizing a Bug-O Systems mechanical device that travels on a magnetic track. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated this date.

Summary of Conversations:

The QC Inspector Informed the QA Inspector that he had performed Visual Testing (VT) inspection on PQR test plate ABF-PQR-025-1B and has accepted it. The QA Inspector also performed VT and on this PQR plate and assigned Lot # B89-017-07 and affixed a green tag onto the face of this PQR test plate.

The QA Inspector was informed by ABF that they will be submitting a Request for Information (RFI) which seeks permission to change the backing bar from A709 Grade 345W to A709 Grade 345. The QA Inspector was informed by ABF that (15) pieces of 1/2 inch A709 Grade 345 plate have been cut and brought to the Ironworkers Apprenticeship Training Facility in anticipation of approval of the above mentioned Request for Information (RFI)

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to use backing bars have been brought on site and the QA Inspector observed that these items are on site and banded together at this time

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	White,Danny	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
